



Date: Tuesday, 16/12/2008 3:06:20 PM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b>	:	CU-DAR001 Dart Helicopters Services		<b>Drawing Name</b>	:	DOUBLER
<b>Job Number</b>	:	44134				
<b>Estimate Number</b>	:	11178				
<b>P.O. Number</b>	:			<b>Part Number</b>	:	D32931
<b>This Issue</b>	:	16/12/2008 <b>S.O. No.</b> :		<b>Drawing Number</b>	:	D3293 REV A
<b>Prsht Rev.</b>	:	NC		<b>Project Number</b>	:	N/A
<b>First Issue</b>	:	/ / <b>Type</b> : SMALL /MED FAB		<b>Drawing Revision</b>	:	A
<b>Previous Run</b>	:	43649		<b>Material</b>	:	
<b>Written By</b>	:			<b>Due Date</b>	:	23/12/2008
<b>Checked &amp; Approved By</b>	:			<b>Qty:</b>		3 <b>Um:</b> Each
<b>Comment</b>	:	Est:A   04.08.24   New issue   KJ/JLM Est Rev:B   Now on Waterjet   06-11-02   JLM				

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 M2024T3S080 2024-T3 .080 sheet



Comment: Qty.: 1.9177 sf(s)/Unit Total : 5.7532 sf(s)  
Material: 2024-T3 (QQ-A-250/4) 0.080" thick  
(M2024T3S.080)  
Identify for D3293-1  
Batch: 109424 UB 8-12-



2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
1-Cut as per Dwg D3293  
Dwg Rev: A  
Prog Rev: A

HB 8-1247

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0      QC8      SECOND CHECK



**Comment:** SECOND CHECK

S 06/12/17 TC

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 44134

Part Number: D32931

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr

*Done at step 4.02 S*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 08/12/17*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*FL 08/12/17 (P)*

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*10:30  
320 OF  
11:00*

*m-1 08/12/17*

*(1X)*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FL 08/12/17 (P)*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*PPD 43817B*

*SS 08/12/17 (X)*

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/01/06  
MF 08/12/17*

Job Completion



*09-01-05*



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED 	APPROVED 	DRAWING NO. D3293	REV. A	
DATE 04.06.28		TITLE DOUBLER	SHEET 1 OF 1	
A	04.06.28	NEW ISSUE	SCALE 1:3	

# D3293-1 DOUBLER

MAKE PER DRAWING FILE "D3293-A1.DWG"

CHECK PER TEMPLATE D3293-1T1

DIMENSIONS SHOWN FOR REFERENCE ONLY

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK

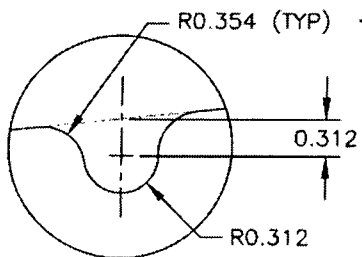
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER

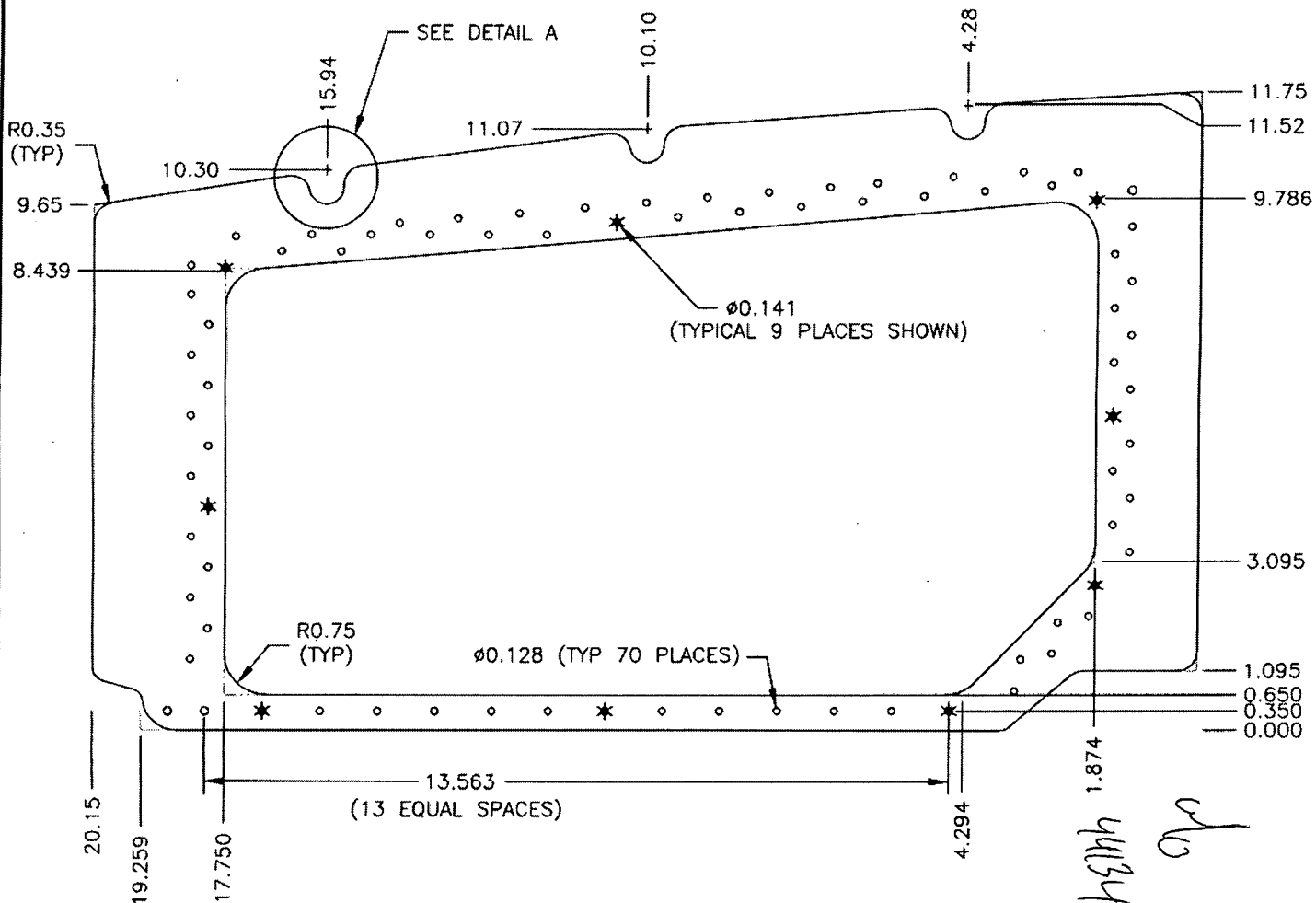
DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DETAIL A  
SCALE 2:3



RELEASED  
04.07.12



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	44134
<b>Description:</b> DOUBLE	<b>Part Number:</b>	D3293-1
<b>Inspection Dwg:</b> D3293-1, <b>Rev:</b> A		Page 1 of 1

**x First Article**[illegible]

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	